

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
							Completed By		
							Lead hand / Supervisor Approval Verification		
							QC / QA Coordinator Approval		
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
OTHER : ☐									

Work Order ID 160263

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160263

Page 2

Item ID: D412-698-044 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Hinge Panel Automatic Door Opener RH OEM Composite Door & Spacedoor™
Start Date: 4/25/2017 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 5/5/2017 Req'd Qty: 1.00 ***1*** Customer:
Reference: SCHEDULED

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Pick Kit	0.00							
130									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D412-698-044								
	Location: _____								
	PPP rev: _____								
	Sold								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

DAS
27
9-89
MAY 04 2017

DAS
21
9-89
MAY 04 2017

DAS
21
9-89
MAY 04 2017

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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
Root Cause				FAULT CATEGORY					
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐				
OTHER :									

Picklist Print

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Page 1

Work Order ID: 160263

160263

Parent Item: D412-698-044

D412-698-044

Parent Item Name: Hinge Panel Automatic Door Opener RH OEM Composite Door & Spacedoor™

Start Date: 4/25/2017

Required Date: 5/5/2017

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 11.08.18 new issue DD verf:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3552-21		Manufactured	No			110	Each	2.0000	1	1			DAS 6 9-89
D3552-21									**			APR 26 2017	SP
Door Prop													

DAS
27
9-89

Location	Loc Qty	Loc Code
ST363	2	
150056	2	

D3622-1		Manufactured	No			110	Each	56.0000	1	1			DAS 6 9-89
D3622-1									**			APR 26 2017	SP
Ball Stud													

DAS
27
9-89

Location	Loc Qty	Loc Code
ST043	56	
156483	16	
158388	40	

D4330-042		Manufactured	No			110	Each	6.0000	1	1			DAS 6 9-89
D4330-042									**			APR 26 2017	SP
Airframe Bracket Assembly, RH													

DAS
27
9-89

Location	Loc Qty	Loc Code
ST093	6	
147391	6	

D4330-3		Manufactured	No			110	Each	0.0000	1	1			DAS 6 9-89
D4330-3									**			MAY 04 2017	SP
Door Bracket													

DAS
27
9-89

160418
MAY 04 2017
SP

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

Picklist Print

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Work Order ID: 160263

160263

Parent Item: D412-698-044

D412-698-044

Parent Item Name: Hinge Panel Automatic Door Opener RH OEM Composite Door & Spacedoor™

Start Date: 4/25/2017

Required Date: 5/5/2017

Start Qty: 1.00

Required Qty: 1.00

MS21042L5 Purchased No 110 Each 182.0000 1 1

MS21042L5

Nut

**

DAS
27
9-89

Location	Loc Qty	Loc Code
GA	16	
m127813	16	
ST303	166	
m136986	1	
m137075	75	
m137164	90	

APR 26 2017

DAS
6
9-89

NAS1149D0563J Purchased No 110 Each 518.0000 1 1

NAS1149D0563J

Washer

**

DAS
27
9-89

Location	Loc Qty	Loc Code
GA	110	
m135774	110	
ST263	408	
m136295	24	
m136986	384	

APR 26 2017

DAS
6
9-89

80-005-2-8 Purchased No 110 Each 258.0000 3 3

80-005-2-8

Insert

**

DAS
27
9-89

Location	Loc Qty	Loc Code
ST585	258	
m130644	258	

APR 26 2017

DAS
6
9-89

MS27039-1-05 Purchased No 110 Each 76.0000 3 3

MS27039-1-05

SCREW

**

DAS
27
9-89

Location	Loc Qty	Loc Code
ST281	76	
m131049	76	

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DAS
6
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Shop Packet Print

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DQA: _____ Date: _____



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QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
								Completed By	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : _____							

Picklist Print

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Work Order ID: 160263

160263

Parent Item: D412-698-044

D412-698-044

Parent Item Name: Hinge Panel Automatic Door Opener RH OEM Composite Door & Spacedoor™

Start Date: 4/25/2017

Required Date: 5/5/2017

Start Qty: 1.00

Required Qty: 1.00

NAS1149D0332J

Purchased

No

110

Each

864.0000

3

3

NAS1149D0332.J

Washer

APR 26 2017

DAS
6
9-89

[Handwritten signature]

DAS
27
9-89

Location

Loc Qty

Loc Code

FP	260	
m136015	8	
m137075	252	
GA	518	
m136643	518	
ST264	86	
m136015	60	
<u>m137075</u>	26	<u>3</u>

3

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

9.0 PARTS LIST – HINGE PANEL AUTOMATIC DOOR OPENER KITS

Qty -041	Qty -042	Qty -043	Qty -044	Part Number	Description
X				D412-698-041	HINGE PANEL AUTOMATIC DOOR OPENER KIT, LH (FOR OEM ALUMINUM DOORS)
	X			D412-698-042	HINGE PANEL AUTOMATIC DOOR OPENER KIT, RH (FOR OEM ALUMINUM DOORS)
		X		D412-698-043	HINGE PANEL AUTOMATIC DOOR OPENER KIT, LH (FOR OEM COMPOSITE AND DART SPACEDOORS™ DOORS)
			X	D412-698-044	HINGE PANEL AUTOMATIC DOOR OPENER KIT, RH (FOR OEM COMPOSITE AND DART SPACEDOORS™ DOORS)
1	1	1	1	D3552-21	GAS SPING
1	1	1	1	D3622-1	BALL STUD
1		1		D4330-041	AIRFRAME BRACKET ASSEMBLY, LH
	1		1	D4330-042	AIRFRAME BRACKET ASSEMBLY, RH
1	1	1	1	D4330-3	DOOR BRACKET
		3	3	80-005-2-8	INSERT
1	1	1	1	MS21042L5	NUT
		3	3	MS27039-1-05	SCREW
		3	3	NAS1149D0332J	WASHER
1	1	1	1	NAS1149D0563J	WASHER

Work Order ID 160263***160263***

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Item ID: D412-698-044

Accept

N900040100Setup Start ***NS1***Stop ***NS2***

Revision ID:

Item Name: Hinge Panel Automatic Door Opener RH OEM Composite Door & Spacedoor™

Start Date: 4/25/2017 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 5/5/2017 Req'd Qty: 1.00 ***1***

Customer:

Reference: SCHEDULED

Run Start ***NR1***Stop ***NR2***

Approvals:

Process Plan:

Date: **APR 25 2017** Tooling:

Date:

QC:

Date: SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

APR 25 2017

IIN-D412-698

F

0.00

APR 26 2017

100

100

DC

Doc.Control -USB or Paperwork

DOCUMENT CONTROL.

Memo

0.00

Photocopy bluefile & type labels per PPPD412-698-044 CHG001

110

110

Packaging

Packaging

Pick Kit

0.00

Memo

0.00

120

120

QC

Quality Control

QC4- 100% Inspect kits for completeness

0.00

Memo

0.00